

Work Order ID 136115

October 06, 2015 10:27:49 AM

136115

Qty 4 to ship Oct 9
or sooner

Documents need to be
Notarized.

Page 1

Item ID: D205-633-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Stop

NS2

Start Date: 8/20/2015 Start Qty: 5.00

5

4 Split?

Cust Item ID:

Required Date: 8/28/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

SK

D20151006

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D205-633	C

100	Document Control	0.00							
-----	------------------	------	--	--	--	--	--	--	--

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP205-633-011 CHG001

DAS
27
9-89

MCS 15-10-07

4

DAS
38
9-89

15-10-07

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110

Packaging

Memo

0.00

Packaging

4X DAS
27
9-89

OCT 06 2015

DAS
02
9-89

120	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Memo

0.00

Quality Control

4

DAS
38
9-89

15-10-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 136115

October 06, 2015 10:27:49 AM

136115

Page 2

Item ID: D205-633-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH
 Start Date: 8/20/2015 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 8/28/2015 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							DA8
130									02
Packaging	Memo	0.00							9-89
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location:FG082								OCT 07 2015
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							MLJ OCT 08 2015
Quality Control									

SA 20151008

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

RQA:

Dist Print

October 06, 2015 10:27:54 AM

Page 1

8

Work Order ID: 136115

136115

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/28/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:F02.07.11Reformat; Removed D3010 RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A		Purchased	No			110	Each	428.0000	1	5			
AN4-14A	DAS 38								**			DAS 27	DAS 02
Bolt	9-89											9-89	9-89
Location Loc Qty Loc Code													
FG 5													
122141 5													
ST325A 350													
M133011 100													
M133284 100													
M133316 150													
ST344 73													
M132677 73													
AN4-5A		Purchased	No			110	Each	146.0000	2	10			
AN4-5A	DAS 38								**			DAS 27	DAS 02
BOLT	9-89											9-89	9-89
Location Loc Qty Loc Code													
CA 55													
m129682 55													
ST325A 50													
m133064 50													
ST345 41													
120562 4													
6651 1													
m132317 36													

OCT 06 2015

Picklist Print

October 06, 2015 10:27:55 AM

Page 4

Work Order ID: 136115

136115

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/28/2015

Start Qty: 5.00

Required Qty: 5.00

D2562-001	DAS	Manufactured	No	110	Each	7.0000	1	5			
D2562-001	38										
Strut 19.68"	9-89										
											DAS 02 9-89

Location	Loc Qty	Loc Code
ST353	7	
134240	3	
134316	4	

D2563	DAS	Manufactured	No	110	Each	4.0000	1	5			
D2563	38										
Step Weldment Assembly	9-89										
											DAS 02 9-89

Location	Loc Qty	Loc Code
FG082	4	
134230	4	

D2565-101	DAS	Manufactured	No	110	Each	11.0000	1	5			
D2565-101	38										
Strut	9-89										
											DAS 02 9-89

Location	Loc Qty	Loc Code
ST353	11	
129688	3	
131707	2	
134294	2	
136106	4	

D2565-103	DAS	Manufactured	No	110	Each	11.0000	1	5			
D2565-103	38										
Strut	9-89										
											DAS 02 9-89

Location	Loc Qty	Loc Code
ST353	11	
121437	1	
131730	3	
134308	3	
136118	4	

Picklist Print

October 06, 2015 10:27:55 AM

Page 5

Work Order ID: 136115

136115

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/28/2015

Start Qty: 5.00

Required Qty: 5.00

D2565-105

Manufactured No

110

Each

11.0000

1

5

D2565-105

DAS
38
9-89

Strut

DAS
02
9-89

Location

Loc Qty

Loc Code

ST353

11

117052

3

131015

1

134444

3

136191

4

DAS
27
9-89

D2565-107

DAS Manufactured No

110

Each

11.0000

1

5

D2565-107

DAS
38
9-89

Strut

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST354

11

130046

1

131128

3

134532

3

136248

4

D2565-109

DAS Manufactured No

110

Each

11.0000

1

5

D2565-109

DAS
38
9-89

Strut

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST354

11

131882

4

134446

3

136192

4

OCT 06 2015

Picklist Print

October 06, 2015 10:27:55 AM

Page 6

Work Order ID: 136115

136115

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/28/2015

Start Qty: 5.00

Required Qty: 5.00

D2565-111

DAS
38
9-89

Manufactured No

110

Each

12.0000

1

5

D2565-111

Strut

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST354

12

131027

1

131892

1

134455

6

136199

4

MS21042L4

Purchased

No

110

Each

1,387.000

8

40

MS21042L4

Locknut

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

112

m127813

112

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1103

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

823

m133316

100

OCT 06 2015

October 06, 2015 10:27:55 AM

Shop Packet Print

Page 6

Picklist Print

October 06, 2015 10:27:55 AM

Page 7

Work Order ID: 136115

136115

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/28/2015

Start Qty: 5.00

Required Qty: 5.00

MS21042L5

Purchased

No

110

Each

374.0000

2

10

MS21042L5

Nut

DAS

38

9-89

DAS

27

9-89

DAS

02

9-89

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST305

228

m127813

19

m131340

21

m132123

8

m132677

180

10

NAS1149D0463J

Purchased

No

110

Each

5,791.000

15

75

NAS1149D0463J

WASHER

DAS

38

9-89

DAS

27

9-89

DAS

02

9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

3500

M133284

2000

M133316

1500

ST269

2250

M129682

86

M130799

371

M132317

101

M132677

888

M133077

804

75

OCT 06 2015

October 06, 2015 10:27:55 AM

Shop Packet Print

Page 7

Picklist Print

October 06, 2015 10:27:55 AM

Page 8

Work Order ID: 136115

136115

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/28/2015

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0563J

Purchased

No

110

Each

944.0000

4

20

NAS1149D0563.J

Washer

DAS

38

9-89

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

428

m130799

63

m132035

55

m132256

10

m133134

300

ST269

444

m128257

156

m132677

288

ST271

19

m131026

19

DAS

27

9-89

DAS

02

9-89

OCT 06 2015

20

REFERENCE ONLY

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: C

Date: 13.12.13